Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2842-042
Job Sheet 215383

Part No: D2842-042 **Job Qty:** 4 pcs
Part Name: Step Assembly RH, 206 Float

Part Weight: 0 lbs **Status:** New **Priority:** Medium
Job Created: 11/12/20 **Job Tracking No:**
Due Date: 12/3/20 **Created By:** Marie Lajeunesse
Type: SOLD **Description:**
Note: DWG REV C IPP Rev:D As Per Ecn 766 06-01-06 JLM
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Standard Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	**Large Fab - Steps - 1**	4 pcs			0.00	5.75	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		CC Dec,2,2020
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
105	**QC 5**	4 pcs			0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22	DAS	
							QC 5 - 24	24	DEC 0 2 2020
							QC 5 - 3	9-89	
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		

DART AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S317616
Part: D2842-042
Job No: 215383
Serial No/Batch: S317616
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 12/02/20

				QC 5 - 82	
110	**Large Fab - Steps - 2 - B4B**	4 pcs	0.00 13.79	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	CC Dec, 4, 2020
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	
120	**QC 9**	4 pcs	0.00 0.00	QC 9 - 10	
				QC 9 - 18 DAS	
				QC 9 - 24 24	DEC 0 7 2020
				QC 9 - 43 9-89	
				QC 9 - 50	
				QC 9 - 9	
130	**QC 5**	4 pcs	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22 DAS	
				QC 5 - 24 24	DEC 0 7 2020
				QC 5 - 3 9-89	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
140	**Handfinish - 1-1 Chemical-B4B**	4 pcs	0.00 1.65	Handfinish - 1 - 1 - B4B	BEB 08/12/2020
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	

			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	
150 **QC 7**	4 pcs	0.00 0.00	QC 7 - 10	
			QC 7 - 13	
			QC 7 - 14	
			QC 7 - 15	
			QC 7 - 17	
			QC 7 - 18	
			QC 7 - 19	
			QC 7 - 2	
			QC 7 - 28	
			QC 7 - 3	
			QC 7 - 30	
			QC 7 - 34	
			QC 7 - 36	
			QC 7 - 37 DAS	DEC 0 8 2020
			QC 7 - 41 81	
			QC 7 - 47 9-89	
			QC 7 - 48	
			QC 7 - 51	
			QC 7 - 58	
			QC 7 - 59	
			QC 7 - 60	
			QC 7 - 9	
			QC 7 - 68	
			QC 7 - 50	
			QC 7 - 67	
			QC 7 - 40	
			QC 7 - 24	
			QC 7 - 43	
			QC 7 - 61	
			QC 7 - 81	
			QC 7 - 76	
			QC 7 - 79	
			QC 7 - 83	
			QC 7 - 82	
			QC 7 - 87	
160 **Large Fab - Steps - 3 - B4B**	4 pcs	0.00 5.75	Large Fab - 1 - B4B	
			Large Fab - 10 - B4B	
			Large Fab - 2 - B4B	
			Large Fab - 3 - B4B	
			Large Fab - 4 - B4B	
			Large Fab - 5 - B4B	
			Large Fab - 6 - B4B	
			Large Fab - 7 - B4B	CC Dec, 8, 2020
			Large Fab - 8 - B4B	
			Large Fab - 9 - B4B	
			Large Fab - 11 - B4B (Various)	
			Large Fab - 12 - B4B	
170 **QC 10**	4 pcs	0.00 0.00	QC 10 - 10	
			QC 10 - 18	
			QC 10 - 24	
			QC 10 - 43	
			QC 10 - 50	
			QC 10 - 58	
			QC 10 - 9	
			QC 10 - 68	

				QC 10 - 81	
180	**QC 5**	4 pcs	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	DEC 0 9 2020
				QC 5 - 51 DAS 81 9-89	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
185	**Handfinish - 2-1 Pressure-B4B**	4 pcs	0.00 1.65	Handfinish - 2 - 1 - B4B	BEB 09/12/2020
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
190	**Powdercoat - 1 White GI(A)-B4B** m 254/469. START: 11:00. OVT: 30' FINISH: 11:30.	4 pcs	0.00 0.70	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	20-12-10. DAS 9-89
				Powdercoat - 4 - B4B	
				Powdercoat - 5 - B4B	
				Powdercoat - 6 - B4B	
				Powdercoat - 7 - B4B	
				Powdercoat - 8 - B4B	
				Powdercoat - 9 - B4B	
				Powdercoat - 10 - B4B	
200	**QC 3**	4 pcs	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	20-12-11 DAS 15 9-89
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	

				QC 3 - 87	
				QC 3 - 47	
210	**Handfinish - 3-1- WingWalk- B4B**	4 pcs	0.00 1.65	Handfinish - 3 - 1 - B4B	ll 20-12-11
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
220	**QC 5**	4 pcs	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	DAS
				QC 5 - 40	DEC 14 2020 40 9-89
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
230	**Packaging 3-1 - Stock - B4B**	4 pcs	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	DAS
				Packaging 3 - 5 - B4B	69
				Packaging 3 - 6 - B4B	9-89
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	DEC 14 2020
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	

				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
240 **QC 21 - SA**	4 pcs		0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DEC 1 4 2020
				QC 21 - SA - 9	DAS
				QC 21 - SA - 77	DAS 2 21 9-89
				QC 21 - SA - 28	

Part Op Descriptions:

100 - (Fabricate per Drwg) 1-Cut D2842-1 using D2622 extrusion as per Dwg D2842 2-Drill D2842-1 using Jig DT8272 as per Dwg D2842 ***DO NOT OPEN HOLES*** 3-Deburr and bevel ends for welding
105 - QC5- Inspect part completeness to step on W/O
110 - (Weld per dwg A/R Aluminum rod Batch:_____) 1-Weld one end cap and (2) lugs using DT10058 as per Dwg D2842 2- OPEN HOLES TO SIZE AS PER DWG (0.250") 3-Grind end cap weld flush
120 - (QC9- Inspect visual per QSI004- Fusion Welds)
130 - (QC5- Inspect part completeness to step on W/O)
140 - (Chemical Conversion Coat per QSI005 4.1)
150 - (QC7-Inspect Chemical Conversion Coat)
160 - (Weld per dwg A/R Aluminum rod Batch:_____) 1-Remove alodine prior to welding. Weld end cap as per Dwg D2842. 2-Grind end cap weld flush.
170 - (QC10- Inspect visual per QSI004- ground welds)
180 - (QC5- Inspect part completeness to step on W/O)
185 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) ***Touch up step with alodine per qsi 005 prior to powder coat***
190 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____
200 - (QC3- Inspect Part Finish)
210 - (Wing Walk as per dwg QSI005 4.4 Batch_____) 1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch:_____
220 - (QC5- Inspect part completeness to step on W/O)
230 - (Identify as per dwg & Stock Location:_____)
240 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	4 pcs (1 ea)	100-Large Fab - Steps - 1	S269726
D2734	Step End Plate	8 pcs (2 ea)	100-Large Fab - Steps - 1	S279216
D3459-1	Float Step Mounting Plate	8 pcs (2 ea)	100-Large Fab - Steps - 1	S241255
D3459-3	Float Step Mounting Plate	8 pcs (2 ea)	100-Large Fab - Steps - 1	S241312
MS27039C1-07	Screw	12 Ea (3 ea)	210-Handfinish - 3-1- WingWalk-B4B	S247846
NAS1149C0332R	Washer (AN960C10L)	12 Ea (3 ea)	210-Handfinish - 3-1- WingWalk-B4B	S304795
NAS1329C3KB130	Insert	12 Ea (3 ea)	210-Handfinish - 3-1- WingWalk-B4B	S023261
NAS1515H3L	Washer	12 Ea (3 ea)	210-Handfinish - 3-1- WingWalk-B4B	S297591

S299272 2x

018623

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Steps - 1	D2622-120C	4	139	0
	D2734	8	109	0
	D3459-1	8	14	0
	D3459-3	8	19	0
210-Handfinish - 3-1- WingWalk-B4B	MS27039C1-07	12	29	0
	NAS1149C0332R	12	3,012	0
	NAS1329C3KB130	12	36	0
	NAS1515H3L	12	124	0

Part Specifications

Specifications could not be found.

Plex 11/12/20 11:55 AM Dart.lajeunesse.marie